

Work Order ID 68974

Tuesday, April 26, 2011 2:29:23 PM



Page 1

Item ID:	D2362-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Support Bracket					
Start Date:	4/26/2011	Start Qty:	12.00	Cust Item ID:		
Required Date:	5/24/2011	Req'd Qty:	12.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	4-24-24	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2362	Rev E1								

100		HAAS CNC VERTICAL MACHINING #1	0.00	B.A 11/06/27	12	0		
	HAAS 1	Memo	0.00					
	HAAS CNC vertical machine #1	1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E <input type="checkbox"/> 2-Deburr per dwg D2362						

110		QC2- Inspect parts off machine FAI/FAIB	0.00	B.A 11/06/27	12	0		
	QC	Memo	0.00					
	Quality Control							

120		QC8- Inspect parts - second check	0.00	B 11.6.28	12	0		
	QC	Memo	0.00					
	Quality Control							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries

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Page 2

Item ID: D2362-3 Accept  Setup Start 
Revision ID:
Item Name: Support Bracket Stop 
Start Date: 4/26/2011 Start Qty: 12.00  Cust Item ID:
Required Date: 5/24/2011 Req'd Qty: 12.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr								
140  Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powder Coating	Memo	0.00							
	START TIME: 9:00								
	330° FINISH TIME: 9:30								
150  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							

12.00 ϕ BL 11-6-30.

12.00 ϕ H 11-6-30



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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WIO: 68974		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.07.04	160	Acceptable to use 3M 1306L B# <u>M117780</u>		11/07/04	12	 11.07.04 (S) 022	N/A

Part No: D2362-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68974

Tuesday, April 26, 2011 2:29:23 PM

Page 4

Item ID: D2362-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Support Bracket

Start Date: 4/26/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/5

ME
11-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 2:29:28 PM

Page 1

Work Order ID: 68974

Parent Item: D2362-3

Parent Item Name: Support Bracket



Start Date: 4/26/2011

Required Date: 5/24/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: G000.05.18 Added inspection level 8 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2397-3 Rubber Cushion		Manufactured	No			100	Each	1.0000	1	12			
<div> <div>Location</div> <div>ST012</div> <div>67593</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2265 Step Bracket		Manufactured	No			160	Each	103.0000	1	12			
<div> <div>Location</div> <div>ST482</div> <div>37477</div> <div>✓44114</div> </div> <div> <div>Loc Qty</div> <div>103</div> <div>9</div> <div>94</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2397-1 Rubber Cushion		Manufactured	No			160	Each	2.0000	1	12			
<div> <div>Location</div> <div>ST012</div> <div>67592</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

4/26/04
B69319 (102)

12 H.A. 11/06/23
4/26/04
2 B69321 (102)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68979
Description: Step Support Bracket		Part Number:	D2362-3
Inspection Dwg: D2362	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	0.260	✓		Vern	6A-01
3.074	+/-0.010	3.074	✓		"	"
0.34	+/-0.030	0.339	✓		"	"
0.77	+/-0.030	0.764	✓		"	"
1.500	+/-0.010	1.499	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
0.80	+/-0.030	0.785	✓		"	"
1.200	+/-0.010	1.201	✓		"	"
1.28	+/-0.030	1.275	✓		"	"
1.000	+/-0.030	1.010	✓		"	"
0.75	+/-0.030	0.758	✓		"	"
1.88	+/-0.030	1.865	✓		"	"

Measured by:	h.a	Audited by:	RF	Prototype Approval:	N/A
Date:	11/06/27	Date:	11.6.28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TF

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED

SUBJECT TO

WITHOUT

WORK ORDER

NO. 68974

10/12/17

DART



RELEASED
98.12.14 KE

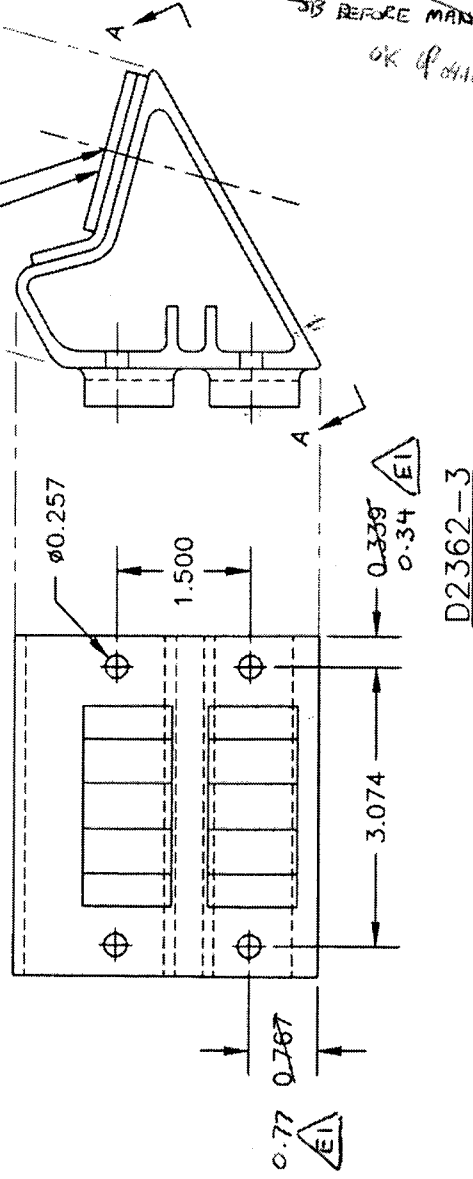
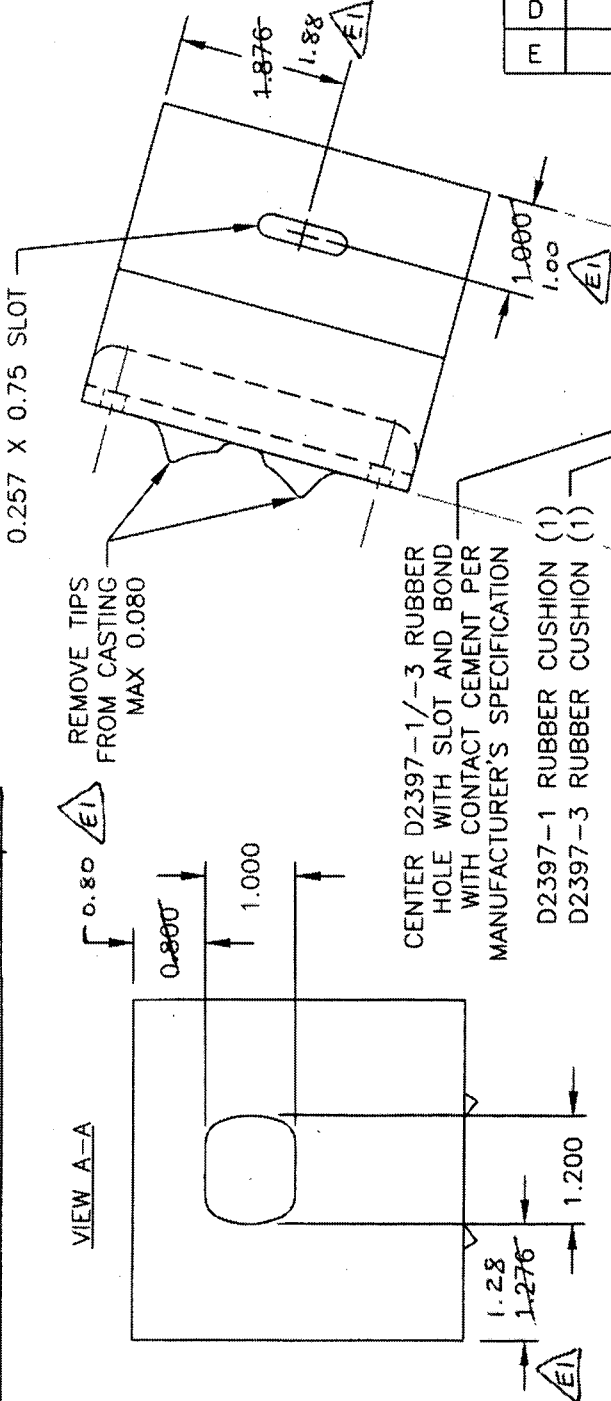
DESIGN BW	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>#</i>	DRAWING NO. D2362	REV. E SHEET 1 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET		SCALE 1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

01.03.15 *CP*

DESIGN OK, BUT CHECK WITH
DIB BEFORE MANUFACTURE

OK *CP* 04.11.09



NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

EI 03.10.07 TOLERANCE CHANGE *#*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2362
DATE	TITLE	SHEET 2 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE
		1:2

11068974

RELEASED
19.12.14
UNDER REVIEW

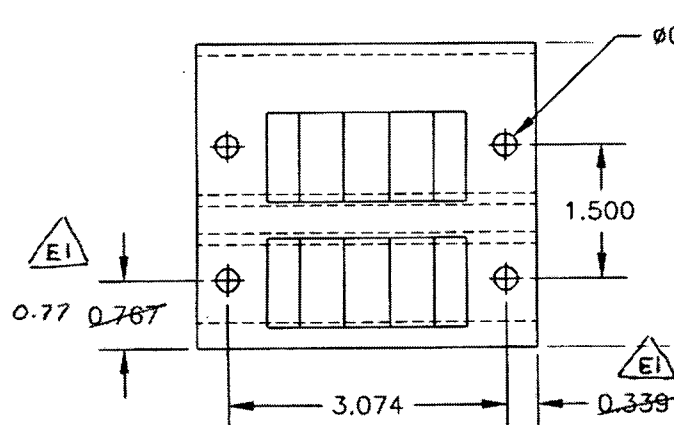
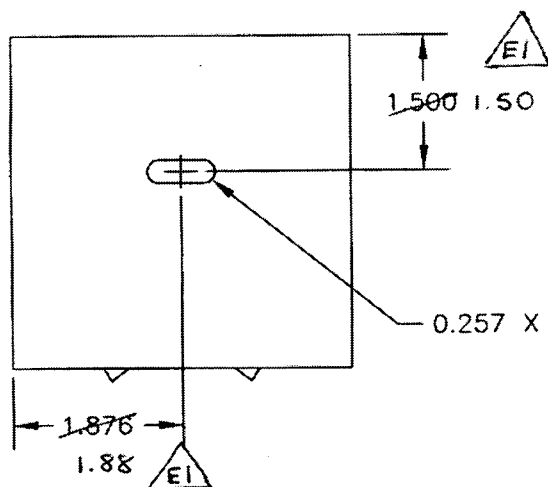
DESIGN OK, BUT CHECK BY
D2362-5 MANUFACTURE
OK 19.1.05

MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080

0.257 X 0.75 SLOT

VIEW A-A



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2362-041 (SHOWN)

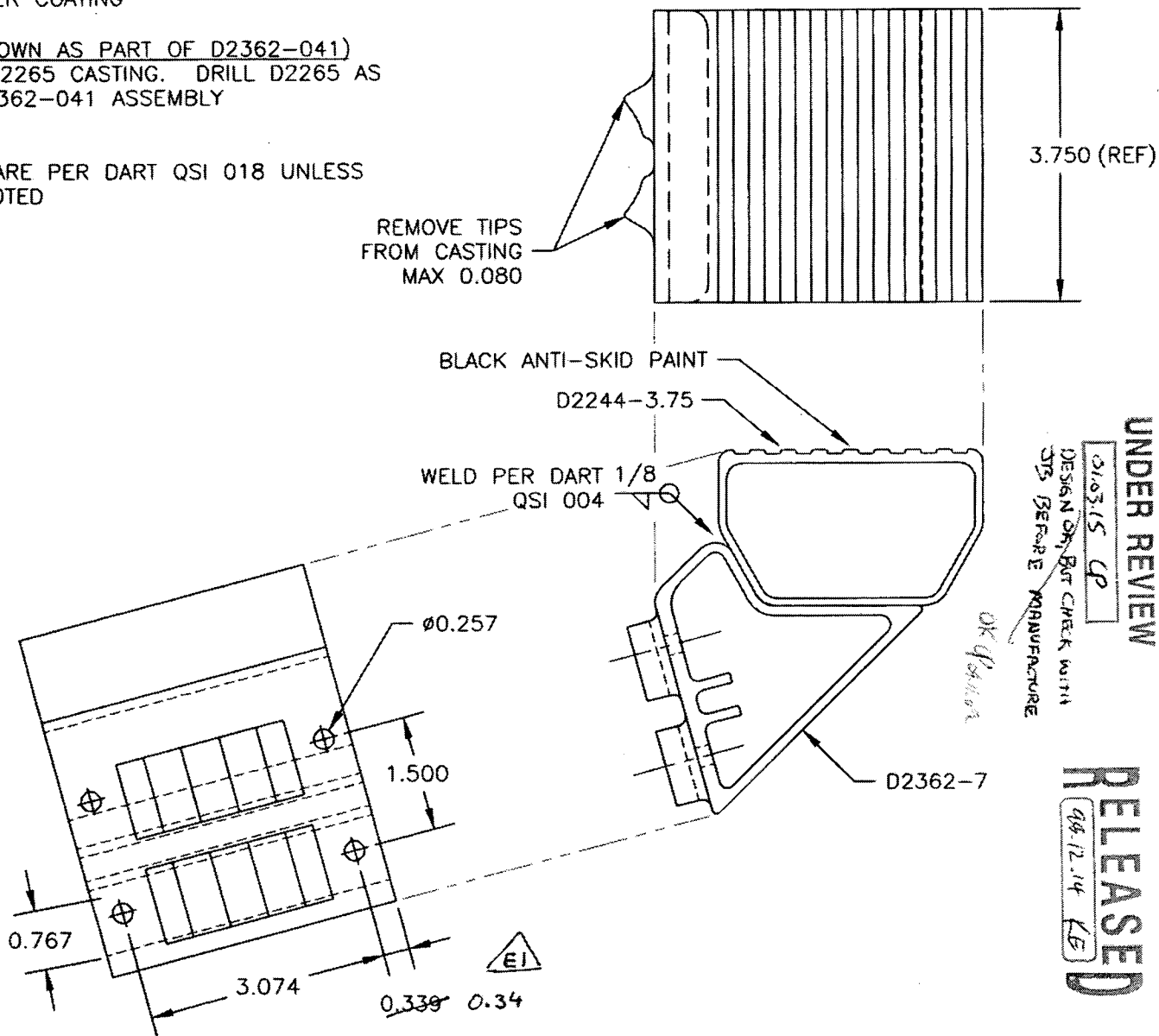
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	REV. E
DATE	98.12.04	TITLE	D2362	SHEET 3 OF 3
		STEP SUPPORT BRACKET		SCALE 1:2

UNDER REVIEW

DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
98.12.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries